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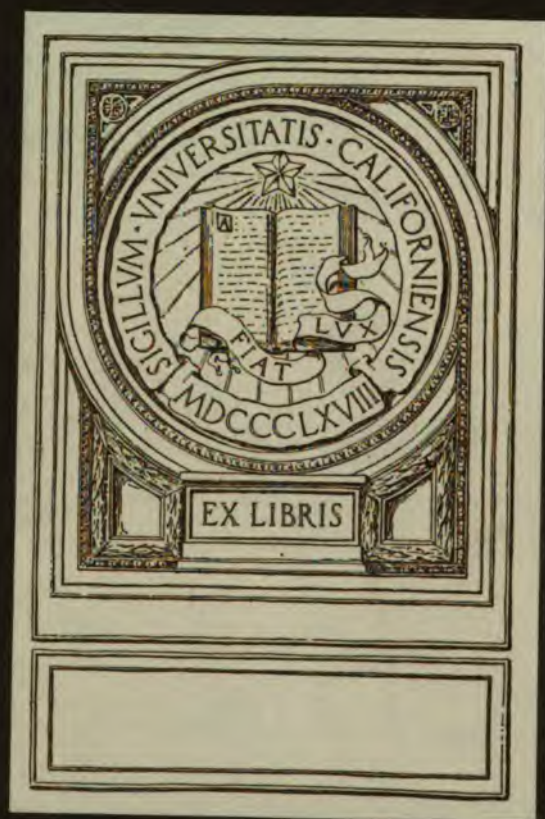
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No. 7

VITREOUS ENAMELING OF IRON AND STEEL

ARTHUR D. LITTLE, Inc.
CHEMISTS AND ENGINEERS
CAMBRIDGE, MASS.



Reprinted from the Journal of the American Ceramic Society.

TO VNU
ASSOCIATES

READING LIST
ON
VITREOUS ENAMELING OF
IRON AND STEEL

Univ. of
California

Compiled by
CLARENCE JAY WEST
Information Department
ARTHUR D. LITTLE, INC.
Cambridge, Mass.

CAMBRIDGE, MASS.
1921

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A READING LIST ON VITREOUS ENAMELING ON IRON AND STEEL

The literature of the ceramic industry is very well covered up to the year 1906 by the Bibliography of Clays and the Ceramic Arts compiled by John C. Branner. The following reading list, therefore, begins with the year 1907. The articles listed deal more with the chemical principles involved than with mechanical methods. References are given to the abstracts printed in Chemical Abstracts or in the Journal of the Society of Chemical Industry. These abstracts are reproduced in part below, though where the abstract is long, or where the title indicates the scope of the article, abstracts are usually omitted. Reference to abstracts will enable the investigator to eliminate many articles as being unsuitable for his particular purpose. United States patents on enameling are omitted, as they are given in the second part of this pamphlet. Directions for ordering foreign patents may be found in Chemical Abstracts, vol. 13, no. 6 (March 20, 1919).

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1912

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- Landrum, Robert D., and Frost, Leon J. Titanium enamels. *J. Am. Ceram. Soc.*, 3, 316-21 (1920); *C. A.*, 14, 2688. The good qualities resulting from the use of titanium seem to more than offset the bad ones and it seems possible to overcome some of the difficulties and develop enamels of very substantial practical value.
- Lindemann, W. C. The electric cleaning of metals for enameling purposes. *J. Am. Ceram. Soc.*, 3, 252-5 (1920). The electric cleaning process is superior to the older scaling or burning off method.
- Metallic coating for the rust proofing of iron and steel. Bureau of Standards, *Circ. No. 80*; *J. Am. Ceram. Soc.*, 2, 844.
- Shaw, J. B. Fish scaling. *J. Am. Ceram. Soc.*, 3, 489-97 (1920); *C. A.*, 14, 2689. Chemical composition has very little bearing on the subject of fish scaling. It is probably due to a number of contributory causes, which are discussed.

UNITED STATES PATENTS RELATING TO ENAMELS WITH SPECIAL REFERENCE TO ENAMELS FOR IRON AND STEEL

The following pages contain a list of the United States patents relative to enamels, with special reference to those for iron and steel for the period 1900-1920. These are arranged chronologically. Wherever possible reference is given to Chemical Abstracts, where a more complete abstract of the patent may usually be found. Reference is also made (the figures in parentheses), to the Official Gazette of the U. S. Patent Office, where the more important, if not all, the claims of the patents are printed. Printed copies of patents are furnished at 10 cents each by the Commissioner of Patents, Washington, D. C.

640,844. Charles H. Watermann. Process of enameling. Jan. 9, 1900. (90, 279).

645,393. Edward C. Hoelscher and John Clifford. Enameling table or machine. Mar. 13, 1900. (90, 2076).

645,517. Christian A. Sievert. Enameling table. Mar. 13, 1900. (90, 2121).

658,833. Edward Dithridge. Enameling table for bath tubs. Oct. 2, 1900. (93, 45).

663,601. William C. Degelman. Apparatus for enameling bath tubs. Dec. 11, 1900. (93, 1911).

663,618. Wilbur Topping. Composition for enameling metal ware. Dec. 11, 1900. (93, 1996).

The formula used was: 61 parts borax, 71 parts feldspar, 44 parts quartz, 15 parts fluorspar, 14 parts soda, 11 parts saltpeter and water.

664,321. Josiah Hughes and James F. McGowan. Ornamental enamel ware. Dec. 18, 1900. (93, 2285).

Variegated enamel ware, the surface of which comprises a body having incorporated and fused therein an enameling material of different color.

669,567. Charles H. Watermann. Apparatus for enameling surfaces of refractory material. Mar. 12, 1901. (94, 1999).

674,506. Joseph H. Hines. Process of enameling metal surfaces. May 21, 1901. (95, 1509).

679,300. William A. Dunpal. Enameling metal. July 30, 1901. (96, 854).

A thin finish coat is applied to a burned ground coat and while this is still wet, a second thin coat of a contrasting color is applied.

684,979. Edward Dithridge. Manufacture of enamels (apparatus). Oct. 22, 1901. (97, 638).

691,268. William Jankowsky. Enameling metal ware. Jan. 14, 1902. (98, 365).

Iron or steel is coated with a suitable primary coating (alkali carbonate) and an enamel coat containing a suitable percentage of primary or acid salt capable of decomposing the film.

700,021. Edward Dithridge. Enameling fork for bath tubs. May 13, 1902. (99, 1542).

707,490. Carl H. Zwerman. Enamel sifting apparatus. Aug. 19, 1902. (100, 1732).

708,363. George W. Ketcham. Art of enameling metal ware. Sept. 2, 1902. (100, 2115).

The cleaned article is coated with a thin layer of cohesive and non-corrosive metal and an enamel then applied which, upon heating, will coact with and only partially oxidize and permeate the coating metal.

709,530. Daniel Wieser. Manufacturer of enameled metal plates. Sept. 23, 1902. (100, 2460).

The plates are coated with a mixture of zinc white and oil varnish, dried, then coated with a greasy lacquer color, dried and rubbed.

710,443. Paul Dupont. Machine for mechanically enameling baths or other metal objects. Oct. 7, 1902. (101, 19).

716,106. Rudolf Rickmann. Manufacture of white or light-colored enamels. Dec. 16, 1902. (101, 2460).

Sodium antimoniate is fused with the enamel.

721,155. Hubert Claus. Enamel machine. Feb. 24, 1903. (102, 1565).

733,831. Samuel H. Frisk. Work holder for enameling. July 14, 1903. (103, 446).

758,325. Thomas M. Sunan. Manufacture of enameled ware. Apr. 26, 1904. (109, 2307).

The cleaned article is coated with an enamel carrying metallic bodies, a non-metallic hydroxide added and heated to flux and set the enamel.

759,351. Edward L. Dawes. Enameling device. May 10, 1904. (110, 380).

762,547. Henry C. Milligan. Process of enameling steel ware. June 14, 1904. (110, 1860).

Steel is pickled, washed, dried, immersed in an acid solution and coated while wet with alkaline liquid enamel, dried and fused.

771,507. Thomas L. Strong. Apparatus for drying enameled ware. Oct. 4, 1904. (112, 1080).

774,478. John S. Jobe. Enameling kiln. Nov. 8, 1904. (113, 420).

774,491. Charles F. Pfalzgraf. Enameling metal. Nov. 8, 1904. (113, 425).

779,655. Julius F. Kenkel. Manufacture of enamel ware. Jan. 10, 1905. (114, 388).

The plate is coated with a preparation of enamel, burned, the plate then slushed in an enamel preparation and the enamel evenly distributed by a blast of air.

793,659. Otto L. Heintz. Enameled ornament. July 4, 1905. (117, 14).

804,010. Julius F. Kenkel. Enameling. Nov. 7, 1905. (119, 203).

An iron or steel article which has a fundamental coat composed of clay and an oxidizing agent and a separately applied glaze coat covering the fundamental coat and forming therewith a mottled finish.

806,153. Walter J. Kohler. Process of making speckled enameled ware and the product thereof. Dec. 5, 1905. (119, 1293).

The process consists of mixing a comparatively small amount of comminuted carborundum with dry pulverized enameling material of one color (different from the carborundum), putting the mixture on the article to be coated with enamel, and then subjecting the article to such heat as fuses the enameling material but less than sufficient to fuse the carborundum.

808,542. Joseph H. Hines. Process of enameling. Dec. 26, 1905. *J. Soc. Chem. Ind.* 25, 1220 (119, 2458).

After cleaning the metal is coated with an alkaline material, the enamel is then applied, a coloring coat applied and burned, and a second coat of enamel applied and burned.

808,744. Otto L. Heintz. Enameled ornament. Jan. 2, 1906. (120, 57).

826,628. Samuel H. Thurston. Process of enameling metal and the resulting product. July 24, 1906. (123, 1061).

The process consists in first forcibly beating one metal into and upon the other systematically and continuously until the particles or molecules of the coating metal are driven into the metal being coated and incorporated with the particles at and beneath the surface of the same.

843,985. Wm. Atkinson and Joseph Smith. Enameling metals. Feb. 12, 1907. *C. A.*, 1, 919. (126, 2390).

Also English patent 12,554. May 30, 1906. *C. A.*, 1, 938.

A flux of white opal cullett 130, sodium bicarbonate 20, and boric acid 12 parts is ground in water to a fine powder, applied to the article and burned.

862,285. Charles R. Schmidt. Method of enameling. Aug. 6, 1907. *J. Soc. Chem. Ind.* 26, 1009, (129, 2175).

The article to be enameled is heated in a rotating enameling chamber or furnace containing dry enamel material.

866,821. Arthur R. Speer. Method of enameling the interior of sheet metal vessels. Sept. 24, 1907. (130, 1092).

868,078. William A. Dunlap. Enameled ware. Oct. 15, 1907. (130, 1772).

869,155. Grace M. Banning. Metal enameling. Oct. 22, 1907. (130, 2321).

906,628. Everett D. Holley. Enamel ware. Dec. 15, 1908. (137, 1528).

932,839. Rudolph Weimer. Substitute for tin oxide for enameling metal ware. Aug. 31, 1909. *C. A.*, 3, 2554. (145, 1165).

The boiled, roasted and ground product of Sb oxide 70, NaOH 28, NaNO₃ 22, kaolin 10 and barytes 10.

971,641. George L. Rice and Benjamin W. Gilchrist. Enameling metallic articles. Oct. 4, 1909. *C. A.*, 5, 31. (159, 49).

A coating containing a magnetic material and sulfur is deposited upon the article electrolytically and the enamel is applied to this.

994,162. Edgar L. Hull. Producing flat watch dials, enameled on one side. June 6, 1910. *C. A.*, 5, 2540. (167, 22).

Both sides are enameled and the enamel then removed from one side by the action of HF.

995,724. C. Rosenzweig. White enamel for glazed goods. June 20, 1910. *C. A.*, 5, 2711. (167, 625).

A glazing mass and a silicate of Zr, Th, Gl, La, or Yt.

996,226. Charles W. Ebeling. Enameling table. June 27, 1911. (167, 832).

1,001,511. J. H. Danver. Making mottled or colored enamels. Aug. 22, 1911. *C. A.*, 5, 3898. (169, 890).

1,017,360. D. A. York and J. A. Tinker. Enameling steel, etc. Feb. 13, 1912. *C. A.*, 6, 920. (175, 424).

1,024,405. K. Kreidl. Making a filler for white enamel. Apr. 23, 1912. *C. A.*, 6, 1666. (177, 987).

Zirconium silicate and sodium hydroxide.

1,033,821. George R. Meyercord. Process of decorating enameled metal. July 30, 1912. (180, 1162).

1,055,678. G. Spitz. Removing the enamel from scrap enameled metal. Mar. 11, 1913. *C. A.*, 7, 1593. (188, 379).

1,065,401. G. Spitz. Removing the enamel from enameled goods. June 24, 1913. *C. A.*, 7, 2845. (191, 862).

1,072,047. Walter L. Shepard. Process of making enameled articles. (194, 129).

1,091,492. H. G. Essayan. Enamel for metals. Mar. 31, 1914. *C. A.*, 8, 1861. (200, 1130).

Heating a mixture of 2 per cent silver, 8 per cent copper and 8 per cent lead, melted together with 82 per cent sulfur and powdering the product.

1,101,455. I. Kreidl. Composition for rendering white enamels opaque. June 23, 1914. *C. A.*, 8, 2932. (203, 1194).

Hydrated alkali zirconate, stannate, or titanate, combined with silica.

1,104,107. T. R. Davidson. Pickling metal to prepare it for enameling. July 1, 1914. *C. A.*, 8, 3102. (204, 742). Also German patent 277,834. July 22, 1913.

Immersed in conc. sulfuric acid at 90-150 degrees, then washed with water at 65 and then at 100 degrees.

1,104,266. M. Mayer and B. Havas. White opaque enamel. July 21, 1914. *C. A.*, 8, 3106. (204, 896).

Contains spinel and preferably small amounts of zirconium, titanium stannic or silicon oxide as opaquing material.

1,104,679. I. Kreidl. Opaque enamel. July 21, 1914. *C. A.*, 8, 3106. (204, 940).

Contains colloidal zirconium oxide.

Reissue 13,791. I. Kreidl. Making an opaque material for white enamels. Aug. 25, 1914. *C. A.*, 8, 3494. (205, 1291).

Natural zirconium silicate is heated with 4 times its weight of sodium hydroxide to 500-600 degrees, washed, dried, and heated to a glowing temperature.

1,117,197. I. Kreidl. White enamel. Nov. 17, 1914. *C. A.*, 9, 136. (208, 682).

The opaquing material is formed of zirconium oxide combined with silica and about 3-4 per cent of alkali metal.

1,118,898. P. Eyer. Enamel glazing. Nov. 24, 1914. *C. A.*, 9, 136. (208, 1314).

1,119,905. C. A. W. Vollrath. Enamel for coating machine. Dec. 8, 1914. *C. A.*, 9, 239. (209, 381).

Finely comminuted colored glass in addition to the ordinary enamel to form a speckled coating.

1,123,760. I. Kreidl. Making a material for opaquing white enamel. Jan. 5, 1915. *C. A.*, 9, 701. (210, 193).

1,124,380. O. Zahn. Muffle furnace for enameling. Jan. 12, 1915. *C. A.*, 9, 701. (210, 454).

1,126,621. A. de Back. Recovering iron and steel from waste enameled articles. Jan. 26, 1915. *C. A.*, 9, 592. (210, 1327).

1,128,691. I. Kreidl. Opaquing materials for enamels, glass, etc. Feb. 16, 1915. *C. A.*, 9, 1103. (211, 797).

Hydrates zinc oxide containing 2-7 per cent combined alkali and a few per cent of water, varying inversely as the amount of alkali.

1,129,300. I. Kreidl. White enamel. Feb. 23, 1915. *C. A.*, 9, 1103. (211, 1047).

The opaquing agent consists of zirconium oxide combined with a small amount of alkali.

1,140,105. Charles Bickmeier and Daniel A. Liston. Continuous-burning furnace for burning enamel ware. May 18, 1915. *J. Soc. Chem. Ind.* 34, 717. (214, 914).

1,150,467. J. Weber. Opaquing composition for use in vitreous enamels. Aug. 17, 1915. *C. A.*, 9, 2701. (217, 871).

Hydrates stannic oxide containing about 10 per cent water and 3-5 per cent of alkali.

1,150,772. I. Kreidl. Opaquing material for white enamels. Aug. 17, 1915. *C. A.*, 9, 2701. (217, 976).

Alkaline compound of zirconium formed by treating with acid and washing to remove part of the combined alkali.

1,153,748. C. Baezner. Opaque enamel or glazing composition for use on sheet iron, etc. Sept. 14, 1915. *C. A.*, 9, 3343. (218, 528).

1,178,469. H. G. Higley. Enameling iron. Apr. 4, 1916. *C. A.*, 10, 1587. (225, 320).

The iron is immersed in a bath prepared from dilute sulfuric acid, ferric oxide and an enamel composition.

1,181,944. J. Weber. Coloring enamels. May 2, 1916. *C. A.*, 10, 1701. (226, 286).

Neutralized anhydrous calcium stannate is used as an opaque coloring.

1,196,342. Alfred de Back. Method of recovering iron, steel, and the like from waste enameled articles. Aug. 29, 1916. (229, 1393).

1,196,243. Alfred de Back. Apparatus for disintegrating metal articles. Aug. 29, 1916. *J. Soc. Chem. Ind.*, 35, 1012. (229, 1393).

1,197,618. Arthur W. Forbes. Enameling apparatus. Sept. 12, 1916. (230, 352).

1,203,409. R. Rickmann. White opaque enamels. Oct. 31, 1916. *C. A.*, 11, 93. (231, 1446).

Small proportion of potassium antimoniate is added.

1,205,845. H. A. Biggar. Enameling composition for use on metals. Nov. 21, 1916. *C. A.*, 11, 198. (232, 869).

A mixture of various asphalts, rosin, Portland cement, etc., is used.

1,220,253. M. Meyer and B. Havas. Opaque white enamels. Mar. 27, 1917. *C. A.*, 11, 1735. (236, 937).

A mixture of titanium oxide and zirconium oxide is used for opaquing white enamels.

1,230,958. K. Warga. Coating aluminium with vitreous enamel. June 26, 1917. *C. A.*, 11, 2323. (239, 989).

1,239,112. H. Kretzer and A. Cappel. Opaque enamels. Sept. 4, 1917. *C. A.*, 11, 3407. (242, 126).

The opacifying agent, *e. g.*, a compound of Zr, Ti, Si, Al, Zn, or alkaline earth metal, is added to the other ingredients of the enamel after they have been at least partially ground in a wet mill, together with substances which precipitate colloids, such as ammonium chloride, magnesium sulfate, or chloride, or sodium sulfate.

1,249,937. P. Eyer. Ground enamel. Dec. 11, 1917. *C. A.*, 12, 414. (245, 469).

Ore containing cobaltic oxide, freed from sulfur and arsenic, is used to color the enamel.

1,256,455, 1,256,456. P. Eyer. Enamel for iron. Feb. 12, 1918. *C. A.*, 12, 986. (247, 433).

White enamel for glass consisting of ruby glass, clay, cryolite and sodium carbonate.

1,268,778. John F. Dodge and Harry C. Allen. Enameling apparatus. June 4, 1918. (251, 200).

1,272,917. R. D. Cooke. Removing enamel from metal surfaces. July 16, 1918. *C. A.*, 12, 1917. (252, 670).

Treated first with HCl (10 per cent) at 70 degrees and then with 25 per cent NaOH at 70 degrees.

1,273,632. William Lindsay. Enameling powder distributor. July 23, 1918. (252, 887).

1,281,762. Frank J. Carpenter. Enameling apparatus. Oct. 15, 1918. (255, 508).

A plurality of contracting members for engaging the rims of articles to be enameled attached to a rotating shaft.

1,285,862. Stefan Wiester. Enamel oven. Nov. 26, 1918. (259 729).

1,290,060. Albert J. Boland. Enameling furnace. Jan. 7, 1919., (258, 11).

1,290,580. W. J. Kohler. Marking enameled ware. Jan. 7, 1919. *C. A.*, 13, 780. (258, 136).

1,311,487. G. H. Benjamin. Enameling kiln. July 29, 1919. *J. Am. Ceram. Soc.*, 2, 852. (264, 772).

1,313,834. I. Rennerfelt. Electric furnace. Aug. 19, 1919. *C. A.*, 13 2642. (265, 424).

The furnace is adapted to melting enamels in crucibles.

1,314,831. F. Preusser. Opaque enamels. Sept. 2, 1919. *C. A.*, 13, 2478; *J. Am. Ceram. Soc.*, 2, 927. (266, 71).

Relatively low content of the usual opacifying agents, such as tin or zinc oxide is used by suitable mixing with other auxiliary ingredients.

1,314,861. P. Eyer. Clouding composition for enamels. Sept. 2, 1919. *C. A.*, 13, 2748; *J. Am. Ceram. Soc.*, 2, 927. (266, 71).

Zirconium borate supersaturated with zinc oxide is used as a clouding material in enamels.

1,316,018. R. D. Cooke. Enameling sheet metal ware. Sept. 16, 1919. *C. A.*, 13, 2986. (266, 306).

Sheet steel is coated with oil and subjected to a drawing operation, the ware then is heated to remove the oil which produces a thin oxide coating on the metal, the enamel is then applied and baked.

1,332,058. C. Musiol. Enamel for metals. Feb. 24, 1920. *C. A.*, 14, 1204; *J. Am. Ceram. Soc.*, 3, 513. (271, 629).

Triple silicate of Al, Na, and Ca mixed with fluorides and coloring substances.

1,335,279. Paul Dupont. Enameling and annealing furnace. Mar. 30, 1920. (272, 804).

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